

Work Order ID 54830

December 22, 2009 2:16:47 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00

Required Date: 1/15/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *09/12/22* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

8/10/24

for CL 10/03/24

110



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: *11005* ☐ Description: D2445 Baggage Door ☐ Supplier:
Delastek ☐ Ship to Delastek (1) D0588-041 label ☐ Certification of Conformity
and process sheet from Delastek is required.

CL 09/12/22 *①*

120



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Certificate of Conformity & Process Sheet are attached

10/01/22 *①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D350-588-041

Revision ID:

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Start Date: 12/22/09 Start Qty: 1.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

Inspect as per Dwg D2445. □ Audit process sheet.

0.00

S 12/23/09

⑦

140



Small Fab

Small Fab

Small Fab

0.00

Memo

Assemble all of the above parts as per Dwg D350-588

0.00

⑧

10-03-11

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 12/23/09

⑨

Phz→

W/O: 54830		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/24	# 150.1	Perman. change ADD step to Pick K.I.T + ADD Routing numbers to Parts. (see w/o 54831)					S 10/03/24

Part No: D350-588.041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC4- 100% Inspect kits for completeness

0.00

8 10/03/24

QC

Memo

0.00

Quality Control

(4)

P107

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

P1143/24 (4)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/24 (4)

C210/3124

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/3/24	# 150.1	Perm. change Missing D2690-17 Part From Parts List to wlo ADD missn D2690-17 B <u>56567</u> qty +1 Per kit	Pc143/p71				J 10/03/24	
		ADD to wlo + Bom- ADD copy of new Bom for Ref.					J 10/03/24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 1

Work Order ID: 54830

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No				Each	136.0000	2.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	136	
104394	3	
113064	100	
113096	33	

ST 10-03-10

x2

AN526C632R8

Purchased

No



Screw

Each 312.0000 8.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	312	
2405	312	

ST 10-03-10

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

Work Order ID: 54830

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Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9		Purchased	No				Each	229.0000	8.0000			



Screw



25 10-03-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	229	
107376	51	
108377	5	
108928	14	
110372	8	
110915	1	
111916	1	
112492	149	

B113840 x 8

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W/O:		WORK ORDER CHANGES					
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Start Date: 12/22/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD10

Purchased

No

Each

1,486.000 2.0000



Washer



ET 10-03-10

NA51149 DO 5635

051 g17
SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1486

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

174

112369

22

113149

1000

B113 288

x 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 54830

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,486,000	2,0000			

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	*1486	
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	48	
112314	174	
112369	22	
113149	1000	

B 113 28%

x2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD8		Purchased	No				Each	1,217.000	16.0000			
----------	--	-----------	----	--	--	--	------	-----------	---------	--	--	--



Washer

~~NAS 11490N8325~~

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1217

107091

9

108335

11

110382

48

110917

3

111578

60

112314

366

112385

720

x16

AN960JD8

Purchased

No

Each

1,217.000 8.0000



Washer

~~NAS 11490N8325~~

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1217

107091

9

108335

11

110382

48

110917

3

111578

60

112314

366

112385

720

x8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2143 Hinge Bracket		Manufactured	No				Each	29.0000	1.0000			
				<u>Warehouse</u> <u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				Main Warehouse				29				
				ST				29				
				37739								
D2144 Hinge Bracket		Manufactured	No				Each	14.0000	1.0000			
				<u>Warehouse</u> <u>Location</u>								
				Main Warehouse				14				
				ST				14				
				41174								
D2150 Packer Doubler, Hinge		Manufactured	No				Each	16.0000	2.0000			
				<u>Warehouse</u> <u>Location</u>								
				Main Warehouse				16				
				ST				16				
				45813								

BT 10-07-10

BT 10-03-10

B 55061 x1

BT 10-03-10
B 55016 10-3-10 sl

B 55016

BT

December 22, 2009 2:16:46 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

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Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2151

Manufactured

No

Each

60.0000

2.0000



Packer Doubler, Hinge



10-3-24sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

51407

60

Each

34.0000

1.0000

2

D2153

Manufactured

No



Door Prop



10-3-24sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

48373

34

Each

29.0000

1.0000

1

D2154

Manufactured

No



Stud Bracket



10-3-24sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

44890

19

45814

10

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2237

Manufactured

No

Each

64.0000

2.0000



Striker Plate

B55006 10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

46162

9

Main Warehouse

ST022

55

52327

55

f

170.7040 7.2500

D2461

+ 1 @ 87.0"

Manufactured

No



Neoprene "D" Seal

81063/102 measured w/ 80

10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

170.7039842

34304

14.234

39782

156.469984

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2463 Manufactured

No

f

577.1626

7.2500



Seal



1/15/10 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75.3752

31350

1.8278

34305

18.25

41121

3.75

43841

51.5474

Main Warehouse

ST404

501.7873684

50075

501.787368

Each

90.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

64

45888

4

53798

60

Main Warehouse

ST37

26

51526

26

D2585



Mounting Channel



12 10-03-10

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W/O:		WORK ORDER CHANGES					
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D2586		Manufactured	No				Each	89.0000	2.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Door Latch

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45554

47183

50213

89

1

2

86

Each

56.0000

1.0000



RT 10-03-10

D2589



Keys, Key Chain, 350 Hinge

D2589		Manufactured	No				Each	56.0000	1.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--

Warehouse

Loc Qty

Loc Code

Location

HONG KONG

ST

46840

46846

50378

1

15

1

40

Each

66.0000

2.0000



C2-32-25
B-17183 2x 10-3 248P

D2621



Latch Plate, 350 Spacepod

D2621		Manufactured	No				Each	66.0000	2.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46842

66

66

RT 10-03-10

x2

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2857-1

Manufactured

No

Each

29.0000

1.0000



Hinge Bracket

IT 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41166

45788

50235

53464

29

7

4

6

12

Each

25.0000

1.0000

D2857-2

Manufactured

No



Hinge Bracket

IT 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45797

53465

25

13

12

December 22, 2009 2:16:46 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2858-1 Manufactured

No

Each

27.0000

1.0000



Hinge Bracket



10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

43364

3

45798

24

D2858-2

Manufactured

No

Each

19.0000

1.0000



Hinge Bracket



10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

41439

4

45799

15

MS20426AD3-4

Purchased

No

Each

7,765.000

12.0000



RIVET



10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7765

104374

3765

110398

4000

12

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-5		Purchased	No				Each	2,485.000	18.0000			



Rivet, Universal Head



10-3-24 50

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2485	
109031	6	
111916	2479	

MS210421.08



Nut

Purchased

No

Each

453.0000

8.0000



18

25 10-03-10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	453	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	31	
113149	100	
113226	200	

B 113 749 x 8

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No				Each	453.0000	10.0000			



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	453	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	31	
113149	100	
113226	200	

M113749 x 10

MS21042L3

Purchased

No

Each

2,372.000 2.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

IT 10-03-10

12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No				Each	2,372.000	4.0000			
Nut												

RT 10-03-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

x4

MS27039-08-11

Purchased

No

Each

76.0000

2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
111977	76	

x2

December 22, 2009 2:16:47 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54830



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15 		Purchased	No				Each	163.0000	2.0000			
Screw												



IS

10-03-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

163

106903

3

108169

4

109321

4

111916

52

112794

100

x2

D2445P

purchased

C2/10/3/23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

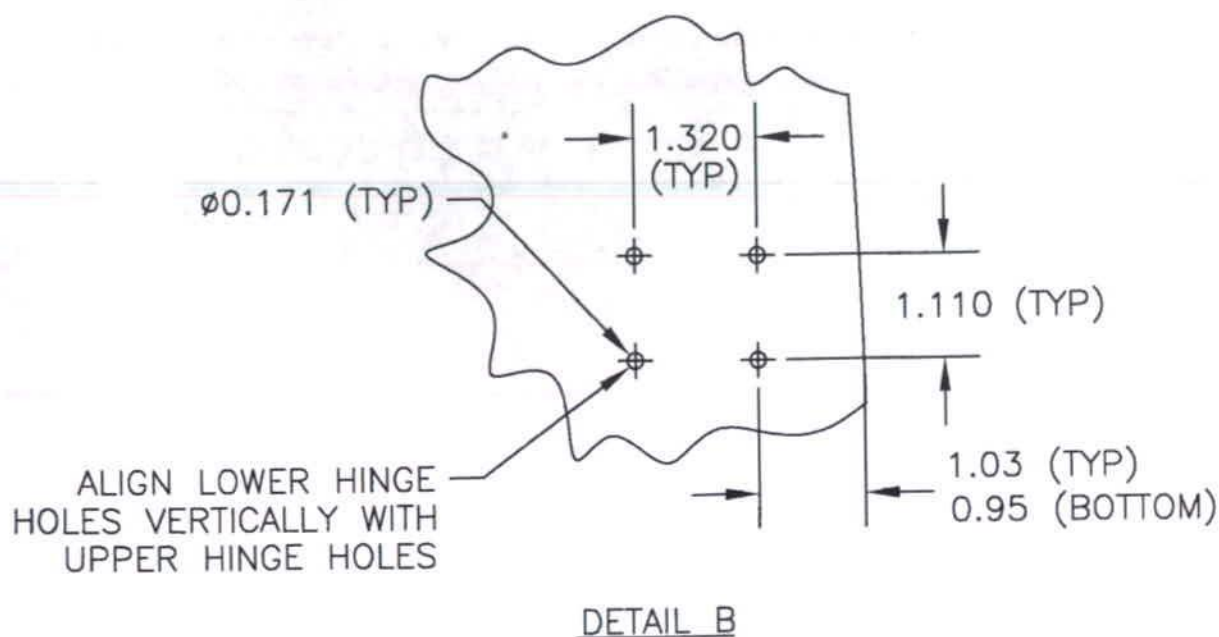
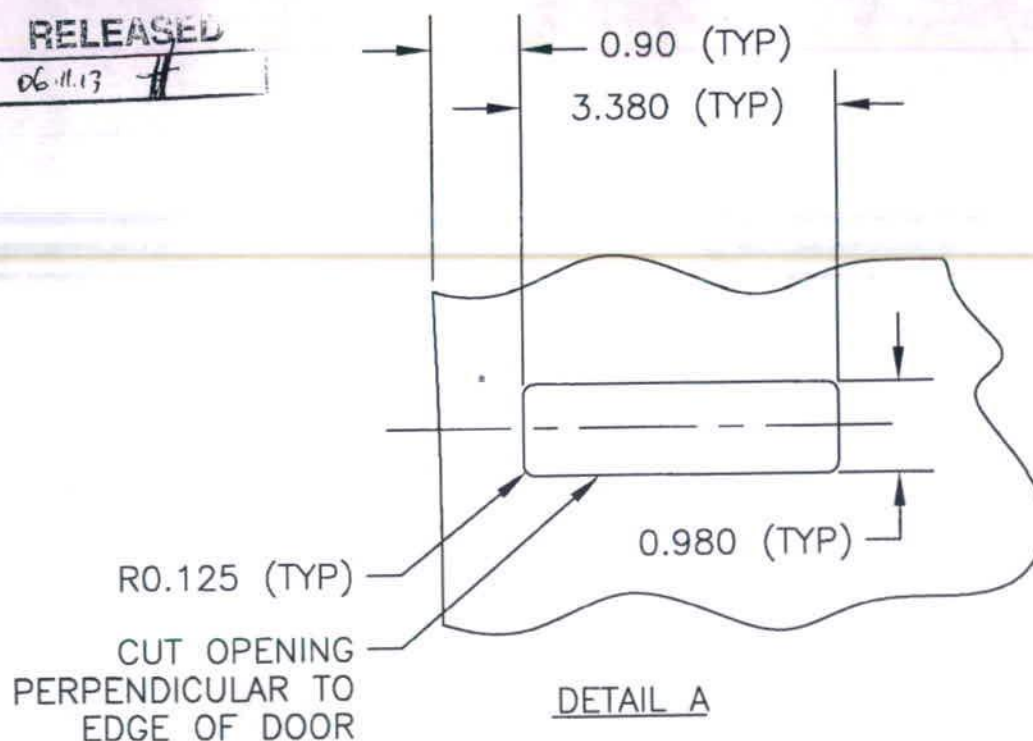
NOTE: Date & initial all entries

DESIGN JB		DRAWN BY CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2445	
DATE 06.06.09		TITLE AFT BAGGAGE DOOR		REV. D SHEET 1 OF 2	
A		97.07.15		NEW ISSUE	
B		02.01.24		ADD D2621; D2445-101	
C		04.02.09		REMOVE D2621; UPDATE NOTES	
D		06.06.09		ADD DIMENSIONS TO PERIMETER	



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED
06.11.13 #



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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13298
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:


Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson		
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233		
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #		
27/01/2010	06/01/2010	6081	Chantal Lavoie		PO11005			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description				
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54830 Drawing N° : D2445 Rév.: D Job: 43642				U de M : Each
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54831 Drawing N° : D2445 Rév.: D Job: 43643				U de M : Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: 

Quality department

AQ-357



☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.

Date: Lundi, 2009-02-09 08:10:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd. Nom Dessin : AFT BAGGAGE DOOR D2445
Numéro Job : 43642 Numéro Article : DKC134-0013
Numéro Soumission : 2017 Numéro Dessin : D2445
Numéro B.A. : Projet Numéro : DKC134
Cette fois : 2009-02-09 No. B.V. : Révision dessin : D
Prsht Rev. : NC Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - - Type : Date Due : 2009-02-16 Qté: 1 Udm: UNITE
Job précédente : 43615



Écrit par : _____

Vérifié & Approuvé par : _____



Commentaires : N° de pièce Dart Aerospace: D2445
N° Delastek Composites: DKC134-0013
N° de projet Delastek: DK-362

Process Sheet Rév.: 10 Modification du planning afin d'y inclure le
N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
		

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
Commentair Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s) Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-6961-1		
4.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-6118-3		

Date: Lundi, 2009-02-09 08:10:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43642

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

5.0	AC0260	Acetone
-----	--------	---------

Commentair Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 10-2-09 Sceau:  Temps Début: 8:30 Temps Fin: 8:45

7.0	GEL COAT.	APPLICATION DE GEL COAT
-----	-----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 10-2-09 Sceau:  Temps Début: 8:45 Temps Fin: 9:00

8.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B

9.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3

10.0	AC0408	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)
Feutre de drainage N° Airweave N 10




Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43642

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
11.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s) Stretchlon 200 poche à vide Vert		
12.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-6925-1</u>		
13.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>1-21729-1</u>		
14.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs PRÉPARATION DU MATÉRIEL DART Tailler le matériel, selon les différents patrons de découpe comme suit: 4 plis de tissus de 9.7 oz. 1 pli de 12 oz. pour tout le contour de la pièce par 5" de large. 3 fois le sac à vide Stretchlon 200. 3 fois le film perforé P-3 3 fois le feutre de drainage 2 fois le tissu à délaminer (non nécessaire lors du bagging du core). Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide. Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres. Date: <u>23-1-09</u> Heure Début: <u>11:00</u> Heure Fin: <u>11:20</u> Sceau: 		
16.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-3</u>		

Date: Lundi, 2009-02-09 08:10:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43642

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.359 KILOGRAMME(s)/Unit Total: 0.359 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-23335-1

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 10-2-09 Heure Début: 12:35 Heure Fin: 12:40 Sceau:



19.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 10-2-09 Heure Début: 12:40 Heure Fin: 12:55 Sceau:



20.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 10-2-09 Heure Début: 12:55 Heure Fin: 1:10 Sceau:



Curing début: 12:40 Curing Fin: 8:00

Feuille de Procédé

Client: DART Dart Aerospace Ltd.








Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43642

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
21.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0042 PINTE(s)/Unit Total : 0.0042 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-3</u>		
22.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-23335-1</u>		
23.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
  Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL DART Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core. Laisser sécher pendant 1 heure. Date: <u>12-2-09</u> Heure Début: <u>12:55</u> Heure Fin: <u>1:00</u> Sceau: 		
24.0	AAC0452	Polybond B46F
Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-6724-1</u>		
25.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) <u>43653</u>		
26.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
  Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRALE DART Retirez le bagging. Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet. Date: <u>13-2-09</u> Heure Début: <u>8:50</u> Heure Fin: <u>9:05</u> Sceau:  		

Feuille de Procédé

Client: DART Dart Aerospace Ltd.




Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43642

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
27.0	POCHE À VIDE 1 	FAIRE LA POCHE À VIDE
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs FAIRE LA POCHE À VIDE</p> <p>Faire la poche à vide en appliquant les composantes dans l'ordre suivant:</p> <ul style="list-style-type: none">1- Film Perforé P-3.2- Feutre de drainage3- Sac à vide Stretchlon 200. <p>Laisser sécher pendant 2 heures minimum.</p> <p>Date: <u>13-2-09</u> Heure Début: <u>9:05</u> Heure Fin: <u>9:10</u> Sceau:  </p> <p>Curing Début: <u>8:50</u> Curing Fin: <u>10:30</u></p>		
28.0	AAC0275	Catalyst N° DDM-9
<p>Commentaire Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>1-6118-3</u></p>		
29.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
<p>Commentaire Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-23335-1</u></p>		
30.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL DART</p> <p>Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>17-2-09</u> Heure Début: <u>11:05</u> Heure Fin: <u>11:10</u> Sceau: </p>		
31.0	LAMINAGE. 	LAMINAGE PIÈCE DART
<p>Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs LAMINAGE PIÈCE DART</p> <p>Faire le laminage d'un pli de 9.7 oz.</p> <p>Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes</p>		

Feuille de Procédé

Cient: DART Dart Aerospace Ltd.
Numéro Job: 43642

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 17-2-09 Heure Début: 11:10 Heure Fin: 11:40 Sceau:  

32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 17-2-09 Heure Début: 11:40 Heure Fin: 11:50 Sceau:  

Curing Début: 11:10 Curing Fin: 4:20

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 18-2-09 Heure Début: 3:30 Heure Fin: 3:35 Sceau: 

34.0

TRIMAGE 1


TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 19-2-09 Heure Début: 9:25 Heure Fin: 9:55 Sceau: 

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43642

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description:

35.0 AAC0062 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041

36.0 AAC0444 Surface Veil

Commentair Qty.: 0.07 VERGE CAR(s)/Unit Total: 0.07 VERGE CAR(s)
Surface Veil

37.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy

38.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 PINTE(s)/Unit Total: 0.007 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy

39.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser scher pendant 4 heures.



Date: 13-1-10 Heure Début: 9h00 Heure Fin: 1h30 Sceau: _____

40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.025 UNITE(s)/Unit Total: 0.025 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6893-1

41.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 18-2-09 Heure Début: 1:15 Heure Fin: 1:30 Sceau: _____
















Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43642

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
43.0	AAC0683	Dupont Primer N° 7704S
Commentaire Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-21723-1</u> <u>1-25612-2</u>		
44.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S
Commentaire Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) Dupont Activator - Reducer Chromabase N° 7775S <u>2-24803-3</u>		
45.0	PRIMER	APPLICATION DE PRIMER
  <div style="text-align: right;"></div>		
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs APPLICATION DE PRIMER Appliquer le primer selon I.G. 0008 Quantité: <u>1</u> Date: <u>23/02/09</u> Sceau:  Quantité: <u>1</u> Date: <u>15/01/10</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____ Quantité: _____ Date: _____ Sceau: _____		
46.0	INSPECTION 3	INSPECTION PIÈCE DART
 		
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs INSPECTION PIÈCE DART Faire l'inspection selon le dessin N° D2445. Date: <u>19-01-10</u> Heure Début: <u>10:15</u> Heure Fin: <u>10:30</u> Sceau: 		
47.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
 		
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs EMBALLAGE ET ENTREPOSAGE Faire l'emballage des pièces. Quantité: <u>1</u> Date: <u>19/1/10</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____		

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries